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ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND WATER--ETC F/G 19/6
INDEX TO BENET WEAPONS LABORATORY (LCWSL) TECHNICAL REPORTS - 1--ETC(U)

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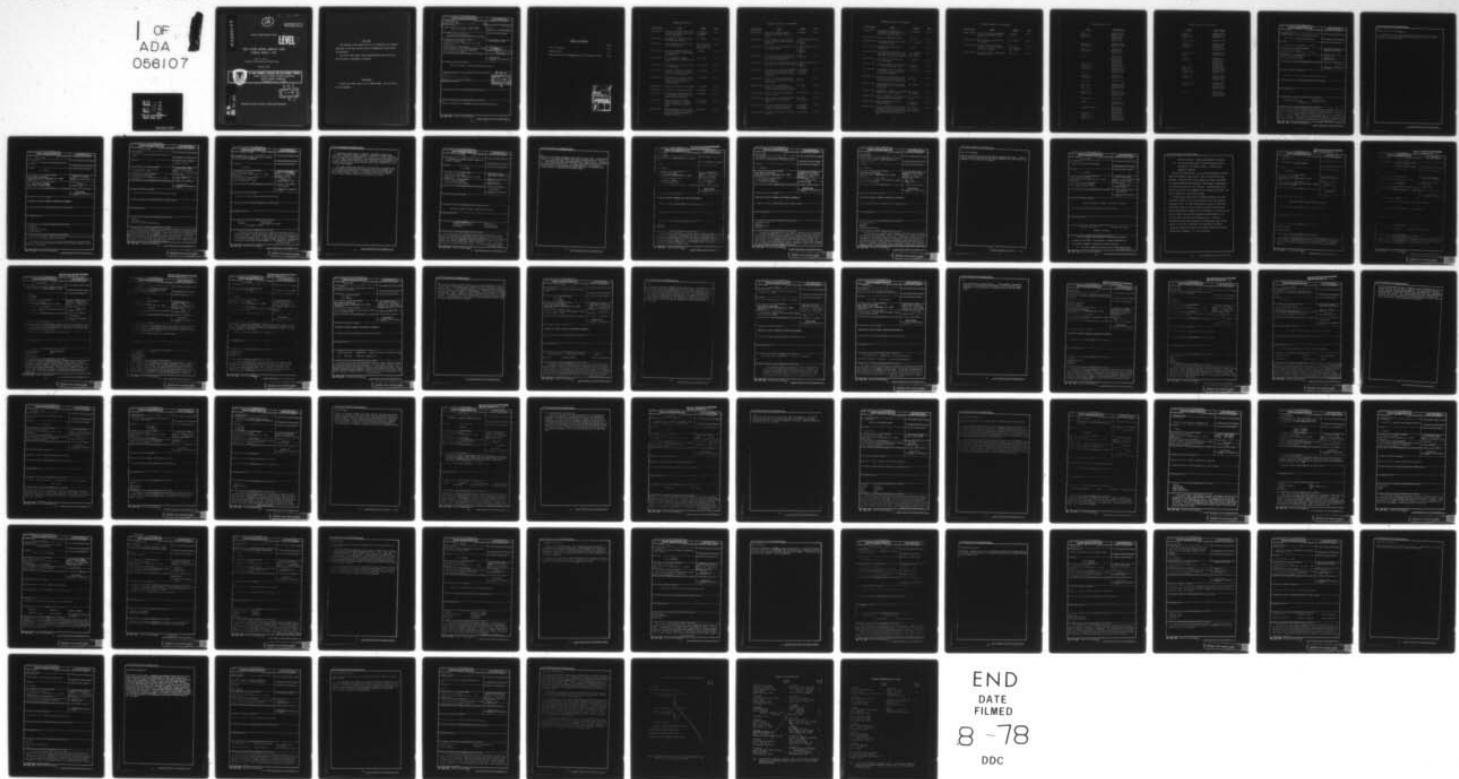
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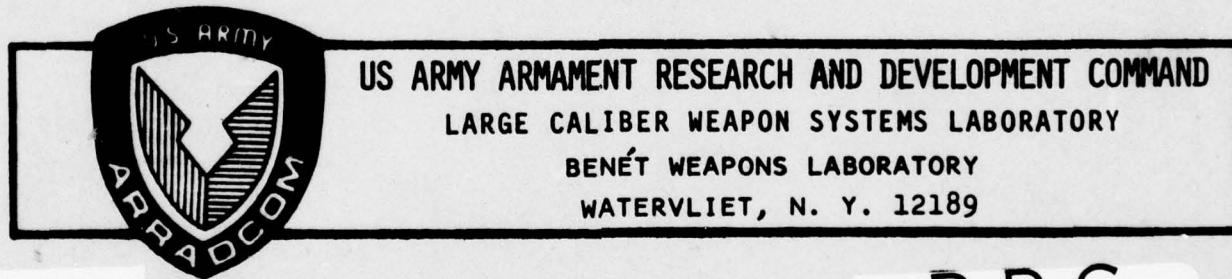
SPECIAL REPORT ARLCB-SP-78003

LEVEL II

INDEX TO BENET WEAPONS LABORATORY (LCWSL)
TECHNICAL REPORTS - 1977

Roy F. Tario
Technical Publications and Editing Unit

February 1978



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19. KEY WORDS (Continue on reverse side if necessary and identify by block number)		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This is a compilation of technical reports published during 1977.		

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1 JAN 73

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problem solutions using FORTRAN IV.

All operations of the stress goniometer, the modular electronic hardware, logic operations and data processing are performed in real time and are completely computer controlled.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77002	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) DEVELOPMENT OF IMPROVED RIFLING PROCEDURES AND EQUIPMENT		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) C. H. LaRoss		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 3297.06.7402 PRON No. M1-4-A1678-01-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Command Rock Island, Illinois 61201		12. REPORT DATE January 1977
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Broaching Gun Barrels Rifling Duplex Process Rifling Machines		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This report describes a process of rifling two 105mm M2A2 gun barrels simultaneously in a horizontal side by side position. The purpose of the project was to reduce significantly rifling machining time of 105mm gun barrels by a process that would be readily adaptable to production line quantities.		

REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-CR-77003	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) MACHINING TESTS AND ANALYSIS ON 1018 AND 4330 STEELS		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s)		6. PERFORMING ORG. REPORT NUMBER DAAA22-75-M-0419
9. PERFORMING ORGANIZATION NAME AND ADDRESS Metcut Research Associates Inc. Cincinnati, Ohio 45209		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 3297.16.7119 Pron No. M1-2-23084-01-M7-M7
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Carbide High Speed Steel Optimum Tool Geometry Application		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) An examination of the report "An Investigation to Determine the Single Point Cutting Tool Angles Which Yield Maximum Tool Life by Response Surface Methodology and Evolutionary Operation of Processes," Lloyd Louis Lehn (thesis submitted in partial fulfillment of the requirements for the degree of Doctor of Philosophy in Mechanical Engineering in the Graduate College of the University of Illinois, 1967), necessitated determining the optimum tool geometry which could be used to grind back and side rake tool angles for high speed steel tools. Machining tests and analysis were done on 1018 and 4330 steels.		

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Liquid metal embrittlement is presently considered to result from liquid metal "adsorption-induced reduction in cohesion" of atomic bonds at regions of high stress concentrations in a solid, such as at the tip of cracks or at the sites of crack nucleation. The prerequisites for embrittlement are the same as those for brittle fracture and liquid metal embrittlement is considered a special case of brittle fracture rather than a diffusion or a corrosion type of phenomena.

This paper presents some theoretical considerations (1) concerning the "reduced-cohesion" mechanism of embrittlement and (2) embrittlement to be a special case of brittle fracture. Experimental results utilizing ideal embrittlement systems in support of the mechanism and also in support of various brittle fracture criteria are presented and discussed.

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value of Young's modulus noticeably lower than the static value. The difference between $(E_d)_{11}$ from impact and those from vibration increases with the ratio of E_d/E_m —thus showing the effect of the dispersion of stress velocity. In addition $(E_d)_{22}$ from impact was always lower than those from vibration and was apparently not related to the ratio of E_d/E_m . It is concluded that, in the dynamic characterisation of fibre-reinforced laminate materials, the resonance-free vibration method is preferable to the impact method.

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1. REPORT NUMBER WVT-TR-77006	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) The Stability of a Beam Subjected to a Moving Mass		5. TYPE OF REPORT & PERIOD COVERED
6. AUTHOR(s) G.L. Anderson		7. CONTRACT OR GRANT NUMBER
8. PERFORMING ORGANIZATION NAME AND ADDRESS Watervliet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189		9. PROGRAM ELEMENT, PROJECT, AREA & WORK UNIT NUMBERS AMCMIS No. 611102.11.8530 DA Proj. No. 1T161102E11A Proj. No. A1-5-51700
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18. KEY WORDS (Continue on reverse side if necessary and identify by block number) Stability Vibrations		
19. ABSTRACT (Continue on reverse side if necessary and identify by block number) The parametric stability of a slender, elastic simply supported beam subjected to the action of a concentrated mass moving at constant velocity along its axis is investigated. The Galerkin procedure is applied to reduce the partial differential equation of motion to an ordinary differential equation in time with periodic coefficients. A perturbation procedure is employed to solve this differential equation, and the boundary curves of the fundamental region of instability are determined.		

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1. REPORT NUMBER WVT-TR-77007	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Qualitative Stability Characteristics of a Flexible Missile Subjected to a Circulatory Thrust		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) G.L. Anderson		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 611102.11.35D00 DA Proj. No. 1F161102A35D Pron No. EJ-5-Y0015
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Circulatory Thrust Dynamics Flexible Missile Stability		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) The stability characteristics of an elastic, flexible missile of constant mass, modelled mathematically as a system consisting of three rigid bars elastically hinged at the joints and subjected to a constant circulatory thrust, are examined. Plots of eigencurves are presented and used to identify the regions of stability, divergence, and flutter in related stability maps. For anti-tangential and sub-tangential thrusts, the system is found to be divergent for any sufficiently small, positive thrust. Moreover, flutter does not occur for anti-tangential and super-tangential thrusts.		

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1. REPORT NUMBER WVT-TR-77008	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) The Influence of Support Characteristics on the Stability of an Elastic System Subjected to a Circulatory Force		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) G.L. Anderson		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SAHVV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMCS No. 611102.11.35D00 DA Proj. No. 1F161102A35D Pron No. EJ-5-Y0015
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Dover, New Jersey 07801		12. REPORT DATE March 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 33
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19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Circulatory Force Dynamics Stability Support Characteristics		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) The stability of a vertical double pendulum with elastic joints, mounted on a platform whose horizontal motion is constrained by an elastic spring and subjected to circulatory force, is examined. Attention is focused on the determination of the critical loads of divergence and flutter as functions of the platform mass and spring stiffness parameters, which characterize the effects of the support on the stability of the double pendulum. The frequency equation is derived, and several typical eigencurves are plotted in the load-frequency plane. Stability maps in the load-tangency coefficient plane indi-		

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Block 20 (continued)

cate the existence of regions of stability, divergence and flutter. Certain boundary curves of these regions are strongly dependent upon the values of the parameters that characterize the support.

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ballistic pressure - "single round parametric resonance".

(ii) the periodic applications of ballistic pressure such as encountered in an automatic weapon - "multiple round parametric resonance".

Results show that ballistic cycles currently employed in the 60mm MCAAAC semi automatic cannon are not likely to excite single round resonance. Unusually brief cycles, however, are shown to be capable of producing resonance amplifications of three orders of magnitude in less than twenty cycles of axial vibration. By proper design of the pressure cycle and/or the fundamental axial frequency of the tube, this type of resonance is rather easily avoided.

Further results show that for the 20mm M139 machine gun, amplifications in excess of fifty can be reached in under five seconds of continuous firing. A special application of the work of Krajcinovic and Herrmann leads to a set of instability contours from which the growth (characteristic) exponent can be determined as a function of the ratio of natural and excitation frequencies and the product of the ballistic impulse and the tube slenderness ratio. Control or elimination of multi-round resonance can be maintained either through control of the initial conditions or by designing for mismatch between the transverse frequencies and integral multiples of one-half the excitation frequency, i.e., the firing rate.

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4. TITLE (and Subtitle) PREPARATION OF ECONOMIC ANALYSES		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(S) V. Montouri		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RT-TP		10. PROGRAM ELEMENT NUMBER AREA & WORK UNIT NUMBER AMCMC No. 728011.32500 PRON No. M1-7-R1156
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Economic Analyses Computer Program		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Economic Analyses are required for all MM&T and MOD projects. They require numerous modifications, recalculations and retypings. Computerization of this task has simplified the processes considerably. This memorandum contains instructions for processing data necessary to prepare Economic Analyses.		

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77011	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) VERIFICATION OF NUMERICALLY CONTROLLED MACHINE PROGRAM BY THE AUTOMATIC DRAFTING MACHINE		5. TYPE OF REPORT & PERIOD COVERED
6. AUTHOR(S) B. Concordia		6. PERFORMING ORG. REPORT NUMBER
7. CONTINUATION OF ADDRESS Project Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 WAT-TR-TP		10. PROGRAM ELEMENT, PROJECT, TASK & WORK UNIT NUMBERS AMCOM NO. 3297.06.7434
8. CONTROLLING OFFICE NAME AND ADDRESS U.S. Army Ordnance Research and Development Command Princeton, New Jersey 07801		11. REPORT DATE March 1977
9. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		12. NUMBER OF PAGES 48
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16. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
17. SUPPLEMENTARY NOTES		
18. KEY WORDS (Continue on reverse side if necessary and identify by block number) Numerical Control Automatic Drafting Machine		
19. ABSTRACT (Continue on reverse side if necessary and identify by block number) This is a report on the modifications made to the Gerber automatic drafting program to allow for the verification of numerical controlled machine programs on the automatic drafting machine. Programming changes were made so that the eleven most-used machines at Watervliet Arsenal can be verified.		

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77012	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Dynamic Analysis of Constant Reaction Systems for a Medium Caliber, Anti-Armor, Automatic Cannon		5. TYPE OF REPORT & PERIOD COVERED
6. AUTHOR(s) P. M. Vottis J. K. Jorczak		7. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, NY 12189
8. CONTRACT OR GRANT NUMBER(s)		9. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Princeton, New Jersey 07801
10. PROGRAM ELEMENT, PROJECT, TASK AMCMS No. 662603.11.H7800 DA Proj No. 1W662603AH78 Pron No. M7-6-R0115-07-M7-11		11. REPORT DATE March 1977
12. NUMBER OF PAGES 50		13. SECURITY CLASS. (of this report) Unclassified
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		15. DECLASSIFICATION/DOWNGRADING SCHEDULE
16. DISTRIBUTION STATEMENT (of this Report) Distribution limited to US Government agencies only; test and evaluation; March 1977. Other requests for this document must be referred to Systems Engineering Division, Development Engineering Directorate, Benet Weapons Laboratory, Watervliet Arsenal, Watervliet, N.Y. 12189.		
17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Constant Reaction Constant Force Recoil Medium Caliber Automatic Weapons Guns		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This report addresses the methodology used in determining a constant reaction force recoil system for the Medium Caliber, Anti-Armor, Automatic Cannon (MC-AAAC) Program, Test Bed #2. General theory and equations of motion which describe the primary elements are discussed. Solution is effected by numerical math modeling techniques. The results of a parametric study across ranges of key independent variables and system sensitivity analyses are presented. An optimal system candidate is selected and essential parameters established.		

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
REPORT NUMBER WVT-TR-77013	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Hydraulic Analysis of the Recoil and Counter-recoil Cycle in Medium Caliber, Anti-Armor, Automatic Cannon, Test Bed No. 2		5. TYPE OF REPORT & PERIOD COVERED
6. AUTHOR(s) H. J. Snock		6. PERFORMING ORG. REPORT NUMBER
7. PERFORMING ORGANIZATION NAME AND ADDRESS Battet Weapons Laboratory Watervliet Arsenal, Watervliet, NY 12189		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 662603.11.07300 DA Proj No. 1W602603A73 Pron No. M7-6-R0115-07-117-117
8. CONTROLLING OFFICE NAME AND ADDRESS Army Ordnance Research and Development Command Devon, New Jersey 07801		12. REPORT DATE March 1977
9. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 29
		15. SECURITY CLASS. (of this report) UNCLASSIFIED
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16. DISTRIBUTION STATEMENT (of this Report)

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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)

18. SUPPLEMENTARY NOTES

19. KEY WORDS (Continue on reverse side if necessary and identify by block number)

Medium Caliber
Recoil Mechanisms
Hydraulic Analysis
Automatic Weapons
Recoil Buffer

Guns

20. ABSTRACT (Continue on reverse side if necessary and identify by block number)

In this report the various stages of the recoil and counterrecoil stroke of the Medium Caliber, Anti-Armor, Automatic Cannon, Test Bed No. 2 are analyzed from a hydraulic point of view. The resulting equations relate the damping force created by flow of fluid within the device to the recoil velocity, the internal dimensions of the recoil mechanism, and the properties of the fluid. Working formulas are developed which can be integrated into a computer program for the recoil dynamics of the complete gun barrel-recoil mechanism.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TN-77014	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Failure Investigation--105mm M68 Tubes (SN 16244, 7506, and 11837)		5. TYPE OF REPORT & PERIOD COVERED
6. AUTHOR/EDITOR A. Campbell		6. PERFORMING ORG. REPORT NUMBER
7. ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189		8. CONTRACT OR GRANT NUMBER(S)
9. PERFORMING ORGANIZATION NAME AND ADDRESS U.S. Army Armament Research and Development Command Dover, New Jersey 07801		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCM's No. 4110.16.21369 DA Proj. No. 826834950 (944) Pro. No. GG-5-28268-01-GG-M7
11. CONTRACTING OFFICE NAME AND ADDRESS		12. REPORT DATE March 1977
13. NUMBER OF PAGES 31		14. SECURITY CLASSIFICATION OF THIS REPORT UNCLASSIFIED
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16. DISTRIBUTION STATEMENT (for this Report)

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DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)

18. SUPPLEMENTARY NOTES

19. KEY WORDS (Continue on reverse side if necessary and identify by block number)

Failure Analysis
Malfunction
Adiabatic Shear

20. ABSTRACT (Continue on reverse side if necessary and identify by block number)

This report summarizes the investigation of three 105mm M68 gun tube failures which occurred during routine training exercises in April and May of 1976. The tubes involved were Serial Numbers 16244, 7506 and 11837; the failures occurred at Forts Knox, Lewis and Bliss, respectively. The conclusion of the investigation is that all three malfunctions were caused by premature, in-bore detonation of the projectiles involved.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77015	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Electrodeposited Cu and Cu-Al ₂ O ₃ Alloys: Physical and Mechanical Properties		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) G.R. Lakshminarayanan E.S. Chen F.K. Sautter		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMC Code: 611101.91A0011 DA Proj. No. 1T161101A91A PRON No. 1A-7-51701-02-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Dover, New Jersey 07801		12. REPORT DATE April 1977
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Electrodeposition Codeposition Physical properties Mechanical properties -ties Annealing Dispersion strengthening		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Cu and Cu-Al ₂ O ₃ alloys were electrodeposited from copper sulfate and copper sulfate-Al ₂ O ₃ plating solutions respectively. Aluminum oxides of different sizes and crystalline phases were used as disperoids in the plating solutions. The properties measured for the deposits include the room temperature yield strength, ultimate tensile strength, elongation, hardness and electrical resistivity. The results show that a codeposition of 1.2 to 2.3 vol per cent calcined gamma oxide (See Other Side)		

20.

with copper increased the yield strength for the as-plated deposits by 65 to 145 per cent and the ultimate tensile strength by 35 to 70 per cent. Hardness was also increased for the Cu-Al₂O₃ deposits. Elongation generally decreased with an increase in oxide content in the deposits. Annealed Cu-Al₂O₃ deposits retained their higher strength up to 480°C (800°F), after a decrease in strength was observed. Unlike Cu deposits, annealing decreased the ductility of Cu-Al₂O₃ deposits. The effects of cold rolling were about 6 to 10 per cent higher than those of Cu electrodeposits. The properties of electrodeposits prepared under ultrasonic agitation are also reported.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77016	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Electrodeposition of Cobalt Using an Insoluble Anode		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) G.R. Lakshminarayanan E.S. Chen J.C. Sadak F.K. Sautter		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS Code: 611101.91A0011 DA Proj. No. 1T161101A91A PRON No. 1A-7-51701-02-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Dover, New Jersey 07801		12. REPORT DATE April 1977
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Electrodeposition Electroactive chemicals Oxidation Reduction Insoluble anodes Mechanical properties		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) A method has been developed which permits the use of an insoluble anode to electrodeposit cobalt by the addition of a sufficient amount of an electrochemically active substance such as vanadium pentoxide to the cobalt sulfate plating solution. In the absence of such additions, formation of Co ³⁺ ions and cobalt oxide (Co ₂ O ₃) at the platinum anode results during plating. The effects of the addition of vanadium pentoxide on the electrode process during plating have been investigated through the analyses of various electrolysis products (See Other Side)		

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as a function of additive concentration and plating time. The results show that besides cobalt deposition, vanadium ions of lower oxidation state (V^{++} , V^{+i+} , VO^{++}) are formed at the cathode and these ions seem to be responsible for the reduction and suppression of Co^{3+} ions and the oxide at the platinum anode. It has also been observed that the concentration of the added electro-chemically active substance changed very little indicating no incorporation of vanadium with the deposit during plating. The mechanical properties of the deposits prepared using an insoluble anode are compared with those obtained using a soluble anode.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77018	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) The Effects of Chloride Ion on the Codeposition of Alumina with Copper		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) G.R. Lakshminarayanan E.S. Chen F.K. Sautter		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCAMS Code: 611101.91A0011 DA Proj.No. 1T161101A91A PRON No. 1A-7-51701-02-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Dover, New Jersey 07801		12. REPORT DATE April 1977
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Electrodeposition Codeposition Additives Adsorption		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) The inhibitory effect of chloride ions on the codeposition of Al ₂ O ₃ from acid copper sulfate electrolytes was investigated. In general, increasing the chloride ion concentration in the copper electrolyte reduces the oxide codeposition in the deposits. The maximum chloride ion concentration tolerable is dependent on the size, crystalline phase and nature of the suspended particles.		

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77017	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) The Effects of Pulse Current Plating on the Mechanical Properties of Cobalt and Cobalt-Al ₂ O ₃		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) E.S. Chen F.K. Sautter		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS Code: 611101.91A0011 DA Proj. No. 1T161101A91A PRON No. 1A-7-51701-02-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Dover, New Jersey 07801		12. REPORT DATE April 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 6
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Electrodeposition Codeposition Pulse Current Plating Mechanical Properties Structure Dispersion Strengthening		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) The effect of high current pulses on the mechanical properties of electro-deposited cobalt and Co-Al ₂ O ₃ was studied along with two other variables, ultra-sonic agitation and superimposed direct current. The deposit were prepared at pulse current densities between 0 and 100 A/dm ² , a pulse width of 120 μ sec and a pulse repetition time of 18 msec. The strength and hardness of both cobalt and Co-Al ₂ O ₃ deposits made under these conditions showed substantial increases (See Other Side)		

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over conventionally prepared deposits. The improvement in mechanical properties is attributed to the refinement in grain structure and the enhancement of Al₂O₃ codeposition associated with the use of current pulses.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER WVT-TR-77019	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Ultrasonic and Acoustic Holographic Techniques for Inspection of Composite Gun Tubes and Other Weapon Components		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(S) George P. Capsimalis Giuliano D'Andrea Ralph E. Peterson		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Rensselaer Polytechnic Institute Watervliet Arsenal, Watervliet, N.Y. 12189 SAWV-RT-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMCS No. 611101.91A0011 DA Proj. No. 1T161101A91A Pron. No. M1-7-51701
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Dover, New Jersey 07801		12. REPORT DATE March 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 58
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Acoustics Composite Materials Holography Ultrasonics		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Ultrasonic and acoustic holographic imaging has been shown to be an effective procedure for the nondestructive inspection of flaws and voids in composite and other material structures. Techniques for quantitatively imaging the size, shape and distribution of flaws in composites and conventional materials are discussed. Additionally a number of test results representing applications of ultrasonic and holographic imaging and their adaptation to typical material testing problems are presented.		

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1. REPORT NUMBER WVT-TR-77020	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Effects of Pressure and Thermal Loadings on a Thin Plating Inside a Thick Tube		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(S) San-Li Pu Julian J. Wu		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Battell Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 SARWV-RI-TP		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 611102.11.H4500 DA Proj. No. 1L161102AH45 Pron. No. EJ-7-Y0011
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Dover, New Jersey 07801		12. REPORT DATE March 1977
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Composite Tubes Cracks Plating Stresses Thermal Stresses		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Stress distribution in a thin layer of plating on the bore surface of a thick tube is studied based on the linear theory of elasticity. Several simple mathematical models are used to represent a variety of material and loading conditions. Results from these simple mathematical models indicate that the chrome plating in a gun tube is very likely to crack. Relative mechanical pro- perties of plating materials and tube materials are discussed in order to reduce the stress level in the plating.		

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cut from autofrettaged cylinders, NASTRAN was used to determine the stress intensity factors for this loading geometry. The experimentally observed results show that autofrettage increases the crack growth rate in externally flawed cylinders, but the test did not supply sufficient data to mathematically model the increase. The faster crack growth rate is believed to be caused by the local relaxation of the tensile autofrettage residual stresses due to large plastic zones accompanying crack growth.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77027	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Analytical and Experimental Tube Temperatures in the 8" XM201 Cannon		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) R. G. Gast P. M. Vottis		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMCS No. 664602.12.38900 DA Proj. No. 1W664602D389 Pron. No. 26-6-94012
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE May 1977
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Gun Barrels Guns Heat Transfer Thermal Test Temperature		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) A comparison is made between measured and predicted temperatures in the 8" XM201 cannon. The gross construction of the thermal model is given and data from firing tests on the XM201 cannon are presented. Correlation is found to be good.		

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77028	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) The Abrasion Characteristics of Certain Protective Coatings on Aluminum and Magnesium Alloys		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) A. Campbell W. Mortimer P. Thornton		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 3297.06.7234 Pron No. M1-3-23021-01-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE May 1977
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Abrasion Anodic Coatings Films		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) The abrasion resistances of two finishing systems, one applied to 2014 aluminum and the other to ZK60A magnesium, were evaluated. Both alloys were first anodized. Subsequently, a blue-wash primer and semigloss paint were applied to the 2014 aluminum; the ZK60A magnesium received a polyamide primer and a polyurethane topcoat. The tests, performed to compare the relative abrasion resistances of the two systems, were carried out using the Taber Abraser Model 503. Abrasion rates were measured by a weight-loss technique. (See reverse side)		

Block 20 (cont)

Analysis of the data indicated that, under the test conditions applied, the topcoats contributed little to the overall abrasion resistance of the two coating systems; rather, the anodic layer of each appeared to be the most important parameter. Further, the rate of abrasion of the anodic layer was relatively constant in each case and could be approximated by a straight line relationship. The anodic film on the 2014 aluminum demonstrated significantly better resistance to abrasion than that on the ZK60A magnesium.

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20. of the distribution of fatigue life.

Results of the Monte Carlo studies indicate that (1) the best fit theoretical distributions of fatigue lives are the 2- and 3-parameter lognormal; (2) the greatest variability in fatigue life results from variability in residual stresses followed by variability in initial crack and fracture toughness; and (3) an effective means of increasing safe life might be through better control of the autofrettage residual stresses. Finally, use of the probabilistic model of gun tube fatigue might lead to (1) improved methods for statistical computation of safe life from test data and (2) improvement in the initial design approach for proposed gun tubes.

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20.

results for the material austenitized at 845°C are presented in the form of three dimensional plots and contour maps which interrelate the mechanical property of interest and tempering temperature and time. Examples showing the use of the plots are presented.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77031	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) EROSION IN 81MM MORTAR TUBES		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) V. Peter Greco		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 3210.16.0008 Pron No. M1-3-1K501-(03)-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE July 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 36
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16. DISTRIBUTION STATEMENT (of this Report) Approved for public release; distribution unlimited.		
17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Coatings Mortars Erosion Particles Fins Propellants Gases Tubes Ignition Wear		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) A laboratory erosion tester has been designed and developed for predicting the service performance of protective coating materials in the bores of mortar systems using rounds with tail fins. Due to the use of newly designed ammunition, the service life of 81MM mortar tubes has been reduced to approximately one third of its original life as the result of the formation of three rings on annular groove erosion formed in the bore. Preliminary efforts to apply wear resistant bore coatings and test fire them in the field have been extremely costly and		

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time consuming because of the large number of rounds required (approximately 7500).

The laboratory erosion tester has been designed to ignite the actual tail fin assembly (which causes the erosion) in a chamber which holds eight test specimens to be evaluated at the same time. The erosion rate of the test material can be increased so that less rounds are required, by merely reducing the distance of the jet stream and moving the specimens closer to the tail fin assembly which upon ignition, radially discharges the mixture of hot gases and associated burning particles onto the specimen surface.

This progress report presents the erosive behavior of eight candidate coatings which have been tested in the laboratory erosion tester. Laboratory results have shown that a five mil thick cobalt or cobalt alloy deposit should be suitable to resist erosion and increase the service life of the 81MM mortar system. An overlay of 2/10 of a mil of chromium over cobalt further increases the erosion resistance. Further testing is necessary to specifically determine the best cobalt system and chromium combination. The next effort would be to field test the coating in the actual mortar system to verify the laboratory results.

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REPORT DOCUMENTATION PAGE			READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77032	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER	
4. TITLE (and Subtitle) DEVELOPMENT OF PROTOTYPE PRODUCTION ESR FACILITIES		5. TYPE OF REPORT & PERIOD COVERED	
6. AUTHOR(s) V.J. Colangelo		7. PERFORMING ORG. REPORT NUMBER	
8. CONTRACT OR GRANT NUMBER(s)		9. PERFORMING ORGANIZATION NAME AND ADDRESS Battelle Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 BDRAR-ESB-TL	
10. PROGRAM ELEMENT NUMBER, LABORATORY AREA & WORK UNIT NUMBERS AMCMS No. 3297.06.7550 PRON No. M1-4-A1552		11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801	
12. REPORT DATE July 1977		13. NUMBER OF PAGES 33	
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16. DISTRIBUTION STATEMENT (of this Report) Approved for public release; distribution unlimited.		15a. DECLASSIFICATION/DOWNGRADING SCHEDULE	
17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)			
18. SUPPLEMENTARY NOTES			
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Electroslag Remelting ESR Cast Hollows Near Net Shapes			
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This report describes the procedures employed to produce and develop a technique to manufacture Electroslag Refined Hollows under a contract granted to the Nutek Corp., Washington, Pa. The report describes the approaches taken together with the results obtained for each approach. Drawings and tooling designs are included in the report.			

REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77033	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Automatic Step Threading of Breechblocks		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) C. Rose		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 4497.06.6771 Pron No. M-1-1-23034
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE June 1977
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Threads Step Threads Thread Shaping Blade Type Tooling		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This report details the engineering design, development and application of equipment to produce step threads (constant lead thread on two or more diameters) on the breechblock of cannon. The equipment uses a blade type tool with the part being threaded through shaper type cuts until finish size is reached. The use of this equipment will reduce the floor to floor time from 7.5 hours to 2.0 hours while producing better thread finishes and more accurate dimensional sizes.		

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77035	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) EVALUATION OF 155MM M199 TUBE FORGING PRODUCERS		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) J. Passmore		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 3210.16.0015 PRON No. M7-5-P4850-01-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE July 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 21
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Cannon Tubes Forging Steel		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Two 155mm M199 howitzer tube forgings, produced by different vendors, were destructively tested to determine the quality of each vendor's forgings. Vendor A's forging did not meet military specifications in all cases; several RA values were below specification. Vendor B's forging was found to be acceptable, exceeding the requirements of the specifications in all cases.		

REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77036	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Reinforced Cobalt Alloy Composite for Turbine Blade Application		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) I. Ahmed & J.M. Barranco		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 612105.H840011 DA Project No. 1L162105AH84 PRON No. AW-7-R0003
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE July 1977
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18. SUPPLEMENTARY NOTES Published in SAMPE Quarterly, Volume 8, No. 3, April 1977.		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Superalloys Composites Tungsten Filament Investment Casting Turbine Blade High Temperature Mechanical Properties		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) A composite of 0.42 Vf W-2% Th _{0.2} filament reinforced cobalt base alloy has been developed. It can be fabricated by conventional investment casting process, has a 1093°C (2000°F), 100hr. stress-to-rupture of 206MN/M ² (30Ksi) and a charpy impact strength of 280.0 in-lb at 835°C as compared with 20.6 in-lb for the unreinforced alloy. Also the feasibility of casting a prototype first stage blade of JT9D engine has been demonstrated.		

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-MR-77037	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Investigation of Fastener Failures in 105MM M68 Guns and 152MM M81 and M162 Gun Launchers		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) Morgan D. Longmate		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, NY 12189 DRDAR-LCB-DPD		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 3110.15.0003 PRON No. M7-5-P4818-10-M7-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, NJ 07801		12. REPORT DATE August 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 61
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Hydrogen Embrittlement Cadmium Embrittlement		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This study was performed to determine the cause(s) of the recurring bolt failures occurring on the 105mm M68 and 152mm M81, M162 Gun Systems.		

REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77038	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) VIBRATIONS OF A HELICOPTER ROTOR BLADE USING FINITE ELEMENT-UNCONSTRAINED VARIATIONAL FORMULATIONS		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) J. J. Wu C.N. Shen		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Battlet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 URDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMCS No. 611102.11.H4500 DA Proj. No. 1L161102AH45 PRON No. EJ-7-Y0011-01-EJ-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE September 1977
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18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Beams (Radiation) Rotation Coupling Effect Stability Dynamics Vibration Flutter Helicopter Rotors		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) In the past several years, a numerical method has been developed which is a generalized Rayleigh-Ritz - finite element discretization using the combined concept of Lagrange multipliers and adjoint variables. This approach enables one to deal with problems associated with nonconservative forces, coupling effects and all types of boundary conditions in a routine fashion; and it appears promising in solving the vibration and dynamic stability problems associated with the complicated equations of a helicopter rotor blade. This paper presents (Continued on reverse side)		

Block 20 (cont)

the first application of the general method of the vibration problem of such a rotor blade.

The basic differential equations in this paper are taken from the linear, but fully coupled set developed by Houbolt and Brooks in 1956. These equations are further reduced to a simplest possible case and yet still contain the coupling of flap and root torsion modes. An unconstrained, adjoint variational statement has been established which is both the necessary and sufficient condition for the coupled differential equations and some general, but physical meaningful boundary conditions. The finite element matrix equations are then derived from this variational statement illustrating the way that coupling terms could be handled in general.

The numerical results from some demonstrative examples show that instability of flutter can occur in the range of operational rotor speed due to the coupled motion of flapping and root torsion without any aerodynamic force, if the torsional spring (or the pitch control link) is not sufficiently stiff. This instability does not appear to have been reported previously.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77040	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) PROBABILISTIC MODELS OF GUN-TUBE FATIGUE BASED ON A FRACTURE-MECHANICS MODEL		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) E. E. Coppola		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory watervliet Arsenal, Watervliet, N.Y. 12189 URDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 611102.H540011 DA Proj. No. 1L61102AH54 PRON No. 1A-7-51700-1A-M7
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE October 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 52
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Fatigue Mathematical Models Fracture (Mechanics) Monte Carlo Method Gun Barrels Probability Life Span Simulation		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Two probabilistic models of gun tube fatigue (those of Racicot and of Proschan and Sethuraman) have been recently developed by adding probabilistic elements to a deterministic model of fatigue failure. These probabilistic models are examined to determine if they give adequate representations when certain questionable assumptions are lifted. In addition, the deterministic model is cast into a more general probabilistic framework, and the effects of certain statistical assumptions are examined.		
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Monte Carlo simulation studies are conducted to approximate possible distributions for gun tube fatigue lives. These generated distributions are compared to various theoretical distributions to determine their adequacy in representing fatigue data. A randomizing method of selecting distributions for material properties of the gun tube is used to give some independence from unwarranted assumptions.

Results of the simulation studies indicate that the lognormal distribution generally gives the best fit to the fatigue lives, but in most cases the log-normal distribution can be rejected by goodness-of-fit tests.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77041	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) ISOPARAMETRIC ELEMENTS AS SINGULAR ELEMENTS FOR CRACK PROBLEMS		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) M. A. Hussain W. E. Lorenzen		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCNS No. 611102.11.H4500 DA Proj. No. 1L161102AH45 PRON No. EJ-7-Y0011
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Dover, New Jersey 07801		12. REPORT DATE November 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 56
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Finite Elements Fracture (Mechanics) Isoparametric		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) The quadratic isoparametric elements, which embody the inverse square root singularity, are used for calculating the stress intensity factors at tips of cracks. The elements used are the quadratic quadrilateral (8-node), quadratic triangular (6-node) and three-dimensional quadratic 'brick' (20-node) elements. Singularity elements are obtained in a simple manner by placing the mid-side nodes at quarter points in the vicinity of the crack tip or an edge. These ele- (see reverse side)		

Block 20 (cont)

ments are implemented in NASTRAN as dummy (user) elements. The method eliminates the use of special crack tip elements and in addition, these elements satisfy the constant strain and rigid body modes required for convergence. The stability of two-dimensional elements is also investigated.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77042	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) EFFECT OF DAMPING AT THE SUPPORT OF A ROTATING BEAM ON VIBRATIONS		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(S) J.D.Vasilakis & J.J. Wu		6. PERFORMING ORG. REPORT NUMBER
9. PERFORMING ORGANIZATION NAME AND ADDRESS Batt Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 UNIAR-ICB-71		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBER AMCMS No. 0111021.1 PRON No. EJ-7-Y0011
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon System Laboratory Clermont, New Jersey 07081		12. REPORT DATE October
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 1
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18. SUPPLEMENTARY NOTES

19. KEY WORDS (Continue on reverse side if necessary and identify by block number)

Rotating Beam

Beam Vibrations

Damping

Finite Elements

Variational Statement

20. ABSTRACT (Continue on reverse side if necessary and identify by block number)

The paper presents a formulation for the study of damping effects in dynamic structural problems and a specific application. A finite element formulation is first derived from the versatile unconstrained variational approach. The vibration of a rotating beam is used here as a concrete example. Viscous damping terms at the support can be present due to either local deflection or rotation. These terms can obviously affect the frequencies of the rotating beam. They are easily incorporated in the present formulation using the concept of unconstrained (See Reverse)

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variations. Numerical data will be presented to demonstrate the qualitative as well as quantitative effects on the vibratory behavior of this rotating beam due to such damping terms.

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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77043	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) TEMPER EMBRITTLEMENT IN 4140 SEAMLESS TUBING		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) Steve Tauscher Peter Thornton		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-TL		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS AMCMS No. 3111.16.2223 PRON No. M1-7-RN114-01-M7-1A
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapon Systems Laboratory Dover, New Jersey 07801		12. REPORT DATE November 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 20
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Split Ring Temper Embrittlement Transition Temperature		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) In November 1976, several 155mm Howitzer M185 split rings failed during various stages of manufacture. A failure analysis consisting of metallography, SEM, and mechanical testing, was undertaken. This investigation concluded that the heat treatment was responsible for embrittling the steel, thereby causing the failures. Furthermore, it was shown that the required hardness could not be achieved without seriously compromising the toughness of this material.		

REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77044	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) DESIGN AND PRODUCTION OF BALLISTIC GUNS NOS 2 AND 3 AND THE INITIAL TEST BED GUN FOR THE MEDIUM CALIBER ANTI-ARMOR AUTOMATIC CANNON PROGRAM		5. TYPE OF REPORT & PERIOD COVERED
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) P.M. Vottis R.L. Billington R.C. Sillery		8. CONTRACT OR GRANT NUMBER(s)
9. PERFORMING ORGANIZATION NAME AND ADDRESS Benet Weapons Laboratory Watervliet Arsenal, Watervliet, N.Y. 12189 DRDAR-LCB-DS		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS
11. CONTROLLING OFFICE NAME AND ADDRESS US Army Armament Research and Development Command Large Caliber Weapons Systems Laboratory Dover, New Jersey 07081		12. REPORT DATE November 1977
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 67
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17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Medium caliber Automatic cannon Ballistic gun Test gun		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Design rationale and construction details are presented for Ballistic Guns Nos 2 and 3 and the Initial Test Bed gun for the Medium Caliber Anti-Armor Automatic Cannon Program.		

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temperature dependence is discussed qualitatively. Applications in the areas of resistivity and scattering of x-rays are discussed.

REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER ARLCB-TR-77046	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) EMBRITTLEMENT OF GUN STEEL BY LIQUID LEAD		5. TYPE OF REPORT & PERIOD COVERED
7. AUTHOR(s) M.H. Kamdar		6. PERFORMING ORG. REPORT NUMBER
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19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Fracture Guns Liquid Lead Embrittlement Steel		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) A study has been made of the fracture behavior of gun steel in liquid lead and inert argon environments at 630°K in monotonic, static and cyclic fatigue test conditions. Smooth and notched specimens tested under the above conditions were severely embrittled by liquid lead and failed by intergranular mode as compared to a ductile mode in argon. Smooth specimens tested monotonically and in static fatigue failed in a catastrophic manner near the		
(Continued on reverse side)		

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s yield stress of the steel. Specimens with machined notches and with a fatigue crack at the root of the notch tested in liquid lead failed at the stress intensity values of $35 \text{ Ks}^{\frac{1}{2}}\text{in}$ and $7 \text{ Ks}^{\frac{1}{2}}\text{in}$ static fatigue and cyclic fatigue tests respectively, whereas in inert argon environment fatigue precracked specimens failed in cyclic fatigue at $135 \text{ Ks}^{\frac{1}{2}}\text{in}$. The susceptibility to embrittlement of steel specimens in liquid lead tested in cyclic fatigue was the same whether the notch was as machined or had a fatigue pre-crack at the root of the notch, i.e., embrittlement was independent of the sharpness of the root radii. These and other results are discussed in terms of the prevalent "reduction in cohesion" mechanism of liquid metal embrittlement proposed by Westwood and Kamdar. The critical conditions and prerequisites for the occurrence of embrittlement of gun steel in liquid lead are also discussed.

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7. AUTHOR(s) S.L. Pu M.A. Hussain W.E. Lorenzen		6. PERFORMING ORG. REPORT NUMBER
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19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Fracture Mechanics Finite-Element Method Cubic, quadrilateral Elements Isoparametric Elements Singular Elements Stress Intensity Factors		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) For the 12-node bicubic, quadrilateral, isoparametric elements, it is shown that the inverse square root singularity of the strain field at the crack tip can be obtained by the simple technique of collapsing the quadrilateral elements into triangular elements around the crack tip and placing the two mid-side nodes of each side of the triangles at 1/9 and 4/9 of the length of the side from the tip. This is analogous to placing the mid-side nodes at (continued on reverse)		

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quarter points in the vicinity of the crack tip for the quadratic, isoparametric element.

The advantage of this method are that the displacement compatibility is satisfied throughout the region and that there is no need of special crack tip elements. The stress intensity factors can be accurately obtained by using general purpose programs having isoparametric elements such as NASTRAN. The use of 12-node isoparametric element program APES may be simplified by eliminating the special crack tip elements.

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7. AUTHOR(s) D.M. Gray	8. CONTRACT OR GRANT NUMBER(s)	
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19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Equations of State Funny Sodium Metallic Ammonium Phase Transformations Pressure		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) It has long been known that the ammonium ion NH ₄ ⁺ behaves in many ways like an alkali metal ion. This report discusses a possible transition (under pressure) from a mixture of ammonia and hydrogen (NH ₃ - _{1/2} H ₂) to metallic NH ₄ in the "funny sodium" form. This form may be defined as a lattice composed of metallic NH ₄ ⁺ ions and s-like electrons (one per ion). The ion has the sodium Z number but only seven protons (those from N) are in the nucleus; the		

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other four protons (those from the four H atoms) form a tetrahedral arrangement around the N nucleus. This tetrahedral arrangement is then approximated by a spherical shell at a radius determined by a variational calculation for the total energy of the tetrahedral ion. (The resulting radius lies well out in the ion electron cloud.) Since a Wigner-Seitz polyhedra approach is used no specific lattice structure is considered. We comment on the earlier calculation of Bernal and Massey (BM) and the more recent calculation of Stevenson. Emphasis is on the BM metallic calculation which we have essentially repeated.

The concept of exchange is described, derivation of the Fock equations is given, and the principal equation of BM (one electron outside a closed shell) is then derived from the Fock equations.

The BM equation is then solved by computer for both the no-exchange and exchange-included cases. Our (unsuccessful) attempts to reproduce the BM results for the no-exchange case are described briefly. Our calculation for the exchange-included case is then described in some detail. For this case we find the internal energy at the equilibrium volume to be about 0.5 ev higher than that obtained by BM (our value is very close to Stevenson's -5.36 ev). Stevenson's equilibrium radius is 5.35 a.u., BM's is 4.23 a.u.; we obtain 4.99 a.u., i.e., shifted considerably toward Stevenson's value. In spite of these differences in U vs V between our results and BM's, our Gibbs energy vs pressure curve is about like theirs.

If the Stevenson mixture curve for U vs V is accepted, the BM and the present metallic calculation make a transition to "funny sodium" NH_4^+ unlikely (at least below the N_2O region). Acceptance of the Stevenson metallic U vs V curve would make such a transition unlikely at any pressure. We consider transition to the "funny sodium" form to be unlikely; transition to other metallic forms are probably in the N_2O (and above) range.

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